Work Order ID 103548 June-24-13 1:58:03 PM				*1	035	48*						Page	1
Item ID: Revision ID: Item Name:	D4021-9 Bushing			Accept	*	N9000	40	100)* s	etup Star Stop	ı V.	S1* S2*	. 1
Start Date: Required Date: Reference:	6/24/13 : 7/06/13	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*			Cust Item ID: Customer:							· .
Approvals:	Process D	Plan: MLJ	Date: 13-06-76	Tooling: SPC (Y/N)):	Date			R	kun Stai Sto	, "I V I	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr		Revision Nbr											
D4021	E	3		0.00							 		!
100 Hardinge Hardinge CNC Latl	he Small	Memo TURN AS DWG REV	PER FOLIO FA 868 AND I	0.00	0AS 40 9-8	13/07/	01		80	8			
		FOLIO RE		\$*	AS 9-83)	13/07/08	2					· · · · · · · · · · · · · · · · · · ·	
*110 *110*		QC2- Inspect parts off i	machine FAI/FAIB	0.00	0AS 40 9-8	13/07/	01		50	<u>\$</u>			
Quality Control		меню			OAA AA	13/07/0							

DQA:	A: Date:												7	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE				AEROSPACE
QA Closed:			Date:								Nork Order ı	pdate only		
Work Orde	er:					DISPOSITION				AGAINST [DEPARTMEN			
		i			_	Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	10.					Scrap		Machining Small Fa			Prod. Eng. Coor.			Quality
						Use-as-is		1 There-		Finishing		Rec/Store/Packaging		Other
NCR N	No	•	•			Suspected Unapproved]		Large Fab	Composite		Supplier		
Root	T				Desci	ription of work order update		l Initial	Act	ion	Sign &		1	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	n	QC Inspector
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Landir [_	General	_	1		٠ -				
	_	ending			-	Bend	Щ	1	Program	_	Outside Di			ressure/Forced
	_		t Concer	ntric	_,}	BOM/Route	<u> </u>	Grain		_	Over/Unde			Set-up
	\neg	racks		4	_	Broken/Damage/Defect	ļ	Hardwa		-	Part Incorr		_	emperature/Cure
			k/Ripple	/Wave	<u> </u>	Burrs	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{eta}}}$	1 '	ion Incomplete/Un	·	Part Lost/N	- ·	_	Veld
		uffs 	•		<u> </u>	Contamination	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	1 .	ions Incomplete/L	Inclear	Part Move		\v	Vrong Stock Pulled
	Crushing		<u> </u>	Countersink	<u> </u>	1 ~	ned/off center		Positioned	, ,				
	_	eat Trea			<u> </u>	Cut Too Short	\sqsubseteq	Mislabe			Power Loss	/Surge	<u> </u>	Other
			Strip in	Tube	-	Drawing		Misread						
	_	larks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set						
			equence			Finish		4	Calibration					
	Wave/Twist in Tube			e	1	Fit/Function	1	Out of	Sequence					

Work Ord		3548		*10.3	8548*			Page 2	-
Item ID: Revision ID: Item Name: Start Date:	D4021-9 Bushing 6/24/13	Start Qty: 50.00	*50*	Accept	*N900040	100*	Setup Sta	INTO	=
Required Date: Reference:	: 7/06/13	Req'd Qty: 50.00	*50*		Customer:	_	Run Sta	nrt *NID4*	
Approvals:		n: <u> </u>	Date:	Tooling: SPC (Y/N):	Date:		Sto	*NR2*	,
Sequence ID/ Work Center I 120 *120* QC Quality Control		Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00	Tool ID Tool#	Plan Acce Code Qty	Qty	Reject Insp. Number Stamp	
130 *130* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: <u>WAC</u> C	0.00		_50) × _ //	1. N. 13-07-8	,
140		OC21- Final Inspection -	Work Order Release	0.00		1	12	4h da	

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Memo

140

Quality Control

13/19 85 mr 13-7-9

DQA:	!	_ Date:												
3.4.Cl	; 	D-4			WORK ORDER NON-	-CC	ONFO	RMANCE / UF					_	AEROSPACE
QA Closed:		Date:								Nork Or	der up	odate only		
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	i		,	_	Rework			Skid-tube	Crosstube	7		Water Jet	\Box	Engineering
Part N	O. :				Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality	
	1				Use-as-is		l	noforming	Finishing	Re		re/Packaging	П	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier	-	
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Root				Desc	ription of work order update	ĺ	nitial	Acti	ion	Sign	ո &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Da	te	Verificatio	n	QC Inspector
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-		lot Concer	ntric .	_	BOM/Route	\vdash	Grain		L			tolerance	Ш	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	Ш	Hardwa		<u> </u>	Part Ir			-	Temperature/Cure
-		ink/Ripple	/Wave	-	Burrs			on Incomplete/Un	· –	Part L		•	-	Weld
+	Crushins			<u> </u>	Contamination			ions Incomplete/U	Inclear	Part N			Ш	Wrong Stock Pulled
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1	\	hatter		-	Drill Holes		Off-set			 		<u> </u>		
		eguence		-	Finish	-		Calibration						
		τųt			Fit/Function		Out of S	equence						
			CRWC	RevH										

Picklist Print

June-24-13 1:58:03 PM

Page 1

Work Order ID:

103548

Parent Item:

D4021-9

Parent Item Name:

Bushing

Start Date: 6/24/13

Required Date: 7/06/13

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD

IPP Rev:B as per dwg REV.A

DD 10.02.22 verified by EC IPP Rev.C as per dwg revB DD 10.04.20 verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 304 ROUND BAR 0.375	,	Purchased	No				f	1.3640		4.15	OAS:	13	107/01
				Location		Loc Qty	Lo	c Code			E-89		
				MAT029		1.364							
				12558	85	1.364							
				126	153				4.55	_ &4 ·			

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DQA:	(A: Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		:	Date:			WORK ORDER NOW	-((JINFUI	RIVIANCE / UP		Wo	rk Order up	date only		AEROSPACE
NA/orde Orde						DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS		
Work Orde	er			,		Rework	ıÌ		Skid-tube	Crosstube		¬ \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\			
Part N	lo.					Scrap		Machining Small Fa			\dashv	Water Jet Prod. Eng. Coor.			Engineering
i di ci	···.					Use-as-is			noforming	Finishing	\dashv		e/Packaging		Quality Other
NCR No.				Suspected Unapproved		THETH	Large Fab	Composite	-	Nec/3tol	Supplier	\vdash	Other		
Well Ho.							J						Jupplier	نــا	
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Cause.	Dat	te	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verificatio	n	QC Inspector
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	Bendi	_	Concen	tric	-	Bend BOM/Route	⊢	•	rogram		-	Outside Dim		-	Pressure/Forced
	Crack		Concen	uic	\vdash	BOM/Route Broken/Damage/Defect	<u> </u>	Grain				Over/Under		-	Set-up
	_		/Ripple/	/\ <i>M</i> 2V0	-	Burrs	<u> </u>	Hardwa		مريمانة: مما	\vdash	Part Incorred		_	Temperature/Cure
	Cuffs	y Kirik,	, wibbie)	vvave	-	Contamination	-	1	on Incomplete/Und	· •	-	Part Lost/Mi	ssing	\vdash	Weld
	Crush	ing		-	-	Countersink		1	ions Incomplete/Ur ned/off center	icieai	$\boldsymbol{\vdash}$	Part Moved	drong	Ш	Wrong Stock Pulled
	Heat	_			\vdash	Cut Too Short	-	Mislabe		}	_	Positioned W Power Loss/:	_	\Box	Othor
			Strip in	Tube	\vdash	Drawing	-	Misread		l	<u>'</u>	rower Loss/:	ourge	Ш	Other
	Marks		٠,	· ubc	<u> </u>	Drill Holes		Off-set			-				
					-	Finish		1	Calibration		-				
	Turning Sequence Wave/Twist in Tube				Fit/Function	\vdash		Converse		_					

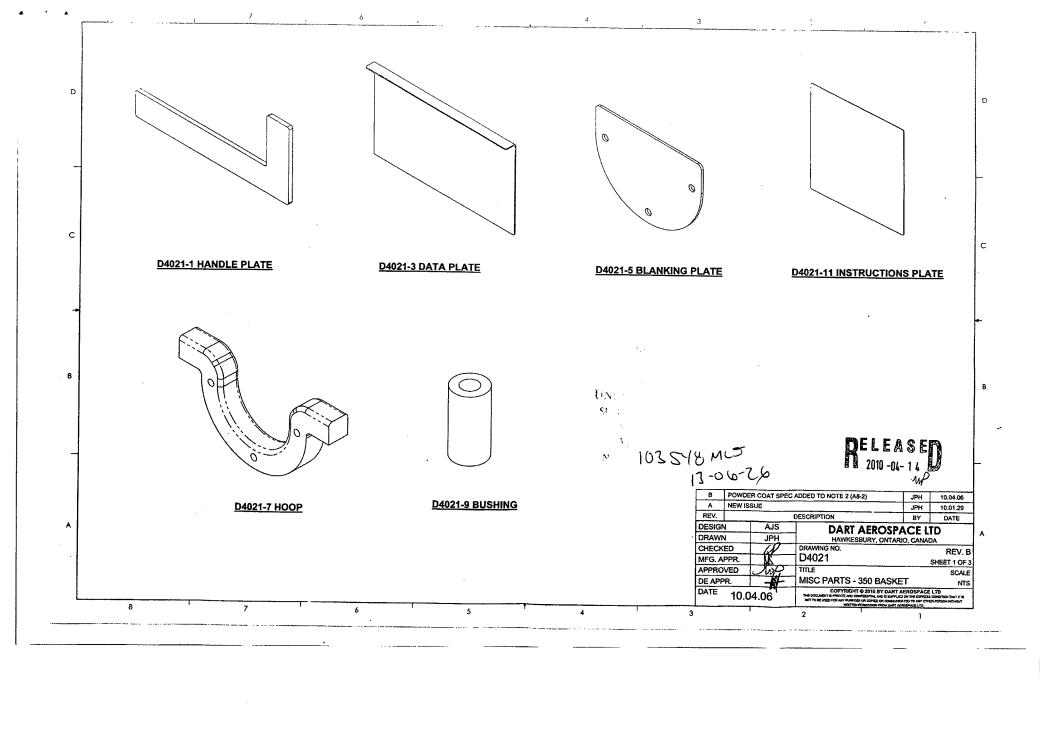
DART AEROSPACE LTD	Work Order:	103548
Description: Bushing	Part Number:	D4021-9
Inspection Dwg: D4021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

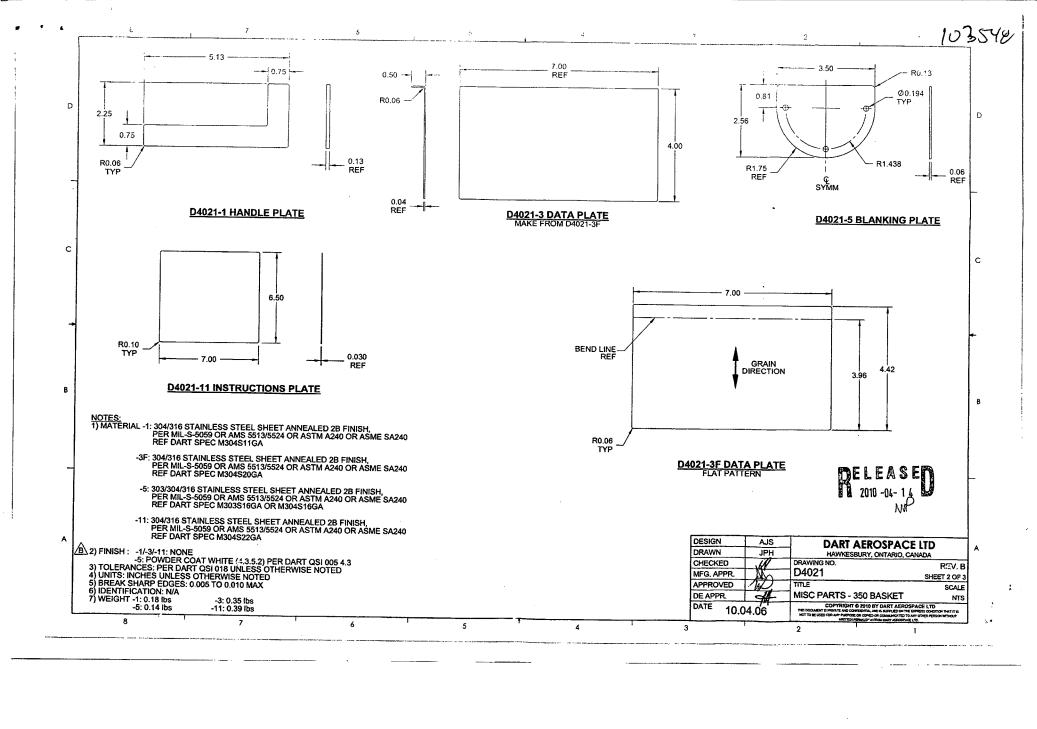
FIRST ARTICLE INSPECTION CHECKLIST										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
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0.75 🕜	+/-0.030	, 752				\				
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54(0.)	JIU4/UI	Date. (7 4-	<i></i>		Date.				

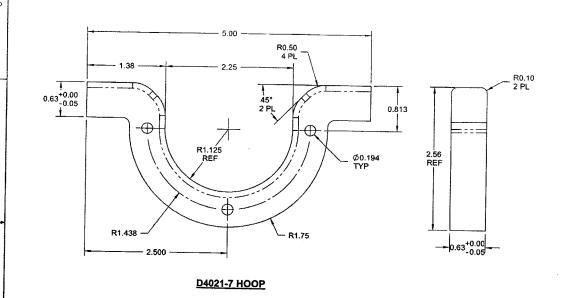
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Measured by:	40 44	Audited by:	2)	Preliminary Approval:	
Date:	13/07/01	Date:	13-1-2	Date:	

Rev	Date	Change	Revised by, Approved	٦
Α	10.06.08	New Issue	KJ A() M	1
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D4021-9 BUSHING

MP

DESIGN AJ\$ DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. B MFG. APPR. D4021 SHEET 3 OF 3 APPROVED TITLE SCALE MISC PARTS - 350 BASKET DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R

REF DART SPEC M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

2